

slip Jan 5

Dart Aerospace Ltd.

Date: Wednesday, 12/20/2006 11:59:01 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 29991	
Estimate Number : 10308	
P.O. Number : <i>N/A</i>	Part Number : D26173
This Issue : 12/20/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : 27738	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/29/2006 Qty: <i>280</i> Um: <i>40</i> Each
Checked & Approved By : <i>[Signature]</i> 06/12/20	
Comment : Est G 04.07.14 Reformat; added step 5KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W
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Comment: Qty.: 0.0765 f(s)/Unit Total : 3.0618 f(s)
6061-T6 Round Bar 1.5"
Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)
Ø0.375" tubing x 0.058" wall
(M6061T6T0.375W.058) Batch: *M19051*

DF 06/12/23

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE
Turn as per Folio FA437 and Dwg D2617

DF 06/12/24 SF 06/12/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DF 06/12/23

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

DF 06/12/23

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr break all unmarked sharp edges 0.005 to 0.010

DF 06/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:59:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29991

Part Number: D26173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

mm / 4:11 a.m.

06/12/28

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mm 06 12 28

(280)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 53*

LB07/01/02

(579)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

707/01/02

(279)

Job Completion



C207101102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

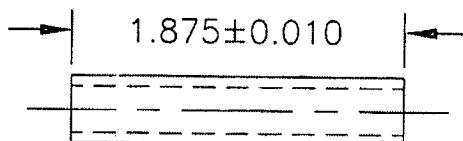
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

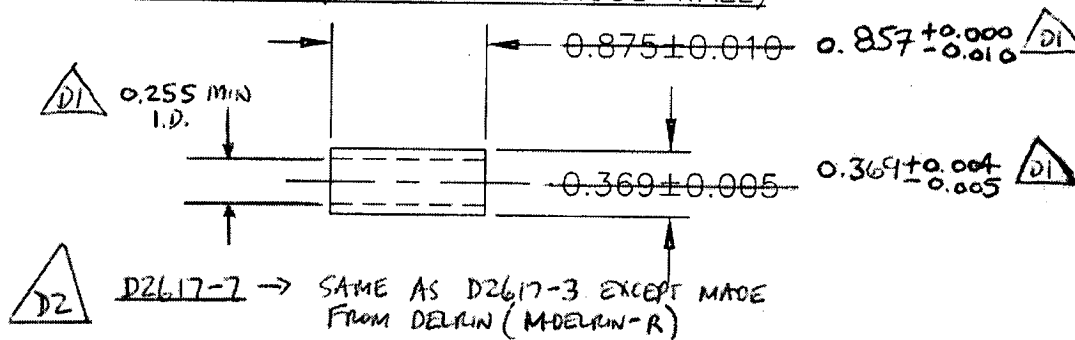


DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H		APPROVED H		DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
A		96.10.08	NEW ISSUE		
B		97.05.08	.875 WAS 1.125		
C		97.06.04	0.369 DIA WAS 0.375		
D		01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE		
DI	CP-H	04.07.12	CORRECT TOLERANCE (NCR 779)		

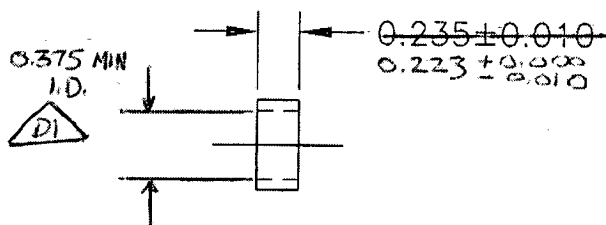
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29991

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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